



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 181602



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: ~~8/28/18~~ **9/12**

Created By: Marie Lajeunesse

Type: SOLD

Description: NO-AIRBUS

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	8/28/18	8/28/18	0.00	0.00	Start Up Large Fab-4		SL4
110	Large Fab	1 pcs	8/28/18	8/28/18	0.00	1.00	Large Fab 2		SL4
120	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC9		SL4
130	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC5		SL4
140	HandFinish	1 pcs	8/28/18	8/28/18	0.00	0.19	HandFinish1		SL4
150	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC7-2		SL4
180	Large Fab	1 pcs	8/28/18	8/28/18	0.00	1.00	Large Fab 2		SL4
190	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC10		SL4
200	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC5		SL4
210	HandFinish	1 pcs	8/28/18	8/28/18	0.00	0.19	HandFinish1		SL4
220	Powdercoat	1 pcs	8/28/18	8/28/18	0.00	0.30	Powdercoat1		SL4
230	HandFinish	1 pcs	8/28/18	8/28/18	0.00	0.19	HandFinish3		SL4
240	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC3		SL4
250	Packaging	1 pcs	8/28/18	8/28/18	0.00	0.00	Packaging1-3		SL4
260	QC	1 pcs	8/28/18	8/28/18	0.00	0.00	QC4		SL4
270	Packaging	1 pcs	8/28/18	8/28/18	0.00	0.00	Packaging3-1		SL4
275	DC	1 pcs	8/28/18	8/28/18	0.00	0.00	DC		SL4
280	QC21-FG	1 Ea	8/28/18	8/28/18	0.00	0.00	QC21		SL4

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: **2:25** OVEN TEMPERATURE: **325°** FINISH TIME: **2:55**

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5090880
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5091443 / 50
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5107707

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :																			

D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

5102256
 5077435
 5057529
 5088307
 5089302
 5099504
 5110581
 5089996
 5102532
 5113205
 5114310
 5094592
 5094597
 5082591
 5095293
 5089299
 5093723
 5088446

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	153	0
	D3219-1	2	159	0
	D3272-1	1	0	0
180-Large Fab	D3065-041	1	16	0
	D3066-1	2	154	0
	MS20600-AD4W4	16	2,212	0
250-Packaging	AN3-35A	2	246	0
	AN4-13A	8	1,633	0
	AN5-36A	2	184	0
	D2230-3	4	7	0
	D2618	2	365	0
	D2856-400-720	2	188	0
	D3235-1	2	136	0
	D3278-041	1	33	0
	MS21042L3	2	4,489	0
	MS21042L4	8	6,226	0
	MS21042L5	2	1,116	0
	NAS1149D0363J	4	1,946	0
	NAS1149D0463J	16	10,343	0
	NAS1149D0563J	4	2,096	0

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Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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			Lead hand / Supervisor Approval Verification																																																	
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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY